

Date: Monday, 7/9/2007 11:46:53 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number : 33354	
Estimate Number : 10834	
P.O. Number : N/A	Part Number : D29332
This Issue : 7/9/2007 S.O. No. : N/A	Drawing Number : D2933 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 32380	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 7/30/2007 Qty: 10 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC	
Est Rev: C As per Rev C 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x 6.25 X 6.00

Grain Along Long 6.00 Length

Batch No: B31396J.F. 07/07/20(10)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

5-Deburr

J.F. 07/07/20(10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

J.F. 07/07/20(10)

4.0	QC1.	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/07/20(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	20						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/27

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:46:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 33354

Part Number: D29332

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

28 07/07/25 (10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Ref 07/07/25 (20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M105068

BR/M/ 07-07-26 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

EP 07/07/27 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP 07/07/27 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20 07/07/27 (10)

Job Completion



U 07-07-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33354
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.118"	.120	.117"	.119"		
B	0.100	0.140		.119"	.121	.121	.119"		
C	0.100	0.140		.120"	.120	.119"	.119"		
D	0.210	0.230		.224"	.220	.223"	.224"		
E	1.245	1.255		1.250"	1.250	1.250"	1.250"		
F	1.245	1.255		1.250"	1.250	1.250"	1.250"		
G	2.495	2.505		2.501"	2.500	2.501"	2.500"		
H	0.510	0.515		.511"	.511"	.511"	.511"		
I	1.572	1.582		1.579"	1.577	1.579"	1.579"		
J	2.495	2.505		2.502"	2.500	2.502"	2.500"		
K	0.257	0.262		Ø.258"	.259	Ø.258"	Ø.258"		
L	0.312	0.317		Ø.314"	.316	Ø.314"	Ø.314"		
M	0.235	0.240		.239"	.239"	.239"	.239"		
N	0.100	0.140		.120"	.119	.120"	.120"		
O	0.540	0.560		.549"	.550	.549"	.548"		
P	0.490	0.510		.506"	.501	.504"	.504"		
Q	3.715	3.725		3.721"	3.719	3.721"	3.719"		
R	2.470	2.510		2.497"	2.492	2.497"	2.497"		
S	0.240	0.270		.254"	.251	.252"	.254"		
T	0.100	0.180		.132"	.140	.132"	.132"		
U	1.625	1.635		1.630"	1.630	1.630"	1.630"		
V	1.362	1.372		1.369"	1.367	1.369"	1.369"		
W	0.316	0.321		Ø.320"	.321	Ø.320"	Ø.320"		
X	1.125	1.145		1.135"	1.134"	1.133"	1.132"		
Y	1.565	1.585	DT8695 A/B	1.575"	1.575	1.575"	1.575"		
Z	0.178	0.198		A.188"	.188	A.188"	A.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.F.
Date:	07/07/24

Audited by:	J.F.
Date:	07/07/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 33354
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.119"	.121"	.121"	.119"		
B	0.100	0.140		.118"	.121"	.115"	.121"		
C	0.100	0.140		.119"	.118"	.119"	.117"		
D	0.210	0.230		.222"	.224"	.225"	.123"		
E	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
F	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
G	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
H	0.510	0.515		.511"	.511"	.511"	.511"		
I	1.572	1.582		1.579"	1.579"	1.579"	1.579"		
J	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
K	0.257	0.262		Ø.258"	Ø.258"	Ø.258"	Ø.258"		
L	0.312	0.317		Ø.314"	Ø.314"	Ø.314"	Ø.314"		
M	0.235	0.240		.239"	.239"	.239"	.239"		
N	0.100	0.140		.119"	.121"	.121"	.120"		
O	0.540	0.560		.549"	.548"	.548"	.550"		
P	0.490	0.510		.504"	.504"	.504"	.505"		
Q	3.715	3.725		3.721"	3.721"	3.721"	3.721"		
R	2.470	2.510		2.497"	2.497"	2.497"	2.497"		
S	0.240	0.270		.254"	.257"	.253"	.252"		
T	0.100	0.180		.132"	.132"	.132"	.132"		
U	1.625	1.635		1.630"	1.630"	1.630"	1.630"		
V	1.362	1.372		1.367"	1.367"	1.367"	1.367"		
W	0.316	0.321		Ø.320"	Ø.320"	Ø.320"	Ø.320"		
X	1.125	1.145		1.134"	1.134"	1.136"	1.135"		
Y	1.565	1.585	DT8695 A/B	1.575"	1.575"	1.575"	1.575"		
Z	0.178	0.198		R.188"	R.188"	R.188"	R.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.F.	Audited by: S.K.
Date: 07/07/24	Date: 07/07/25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 33354
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

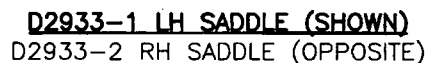
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		1.18"	1.19"				
B	0.100	0.140		1.21"	1.21"				
C	0.100	0.140		1.19"	1.20"				
D	0.210	0.230		2.23"	2.23"				
E	1.245	1.255		1.250"	1.250"				
F	1.245	1.255		1.250"	1.250"				
G	2.495	2.505		2.500"	2.500"				
H	0.510	0.515		1.511"	1.511"				
I	1.572	1.582		1.579"	1.579"				
J	2.495	2.505		2.500"	2.500"				
K	0.257	0.262		0.258"	0.258"				
L	0.312	0.317		0.314"	0.314"				
M	0.235	0.240		0.239"	0.239"				
N	0.100	0.140		1.20"	1.19"				
O	0.540	0.560		1.549"	1.548"				
P	0.490	0.510		1.500"	1.500"				
Q	3.715	3.725		3.721"	3.721"				
R	2.470	2.510		2.497"	2.497"				
S	0.240	0.270		0.252"	0.253"				
T	0.100	0.180		1.132"	1.132"				
U	1.625	1.635		1.630"	1.630"				
V	1.362	1.372		1.367"	1.367"				
W	0.316	0.321		0.320"	0.320"				
X	1.125	1.145		1.134"	1.134"				
Y	1.565	1.585	DT8695 A/B	1.575"	1.575"				
Z	0.178	0.198		0.188"	0.188"				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

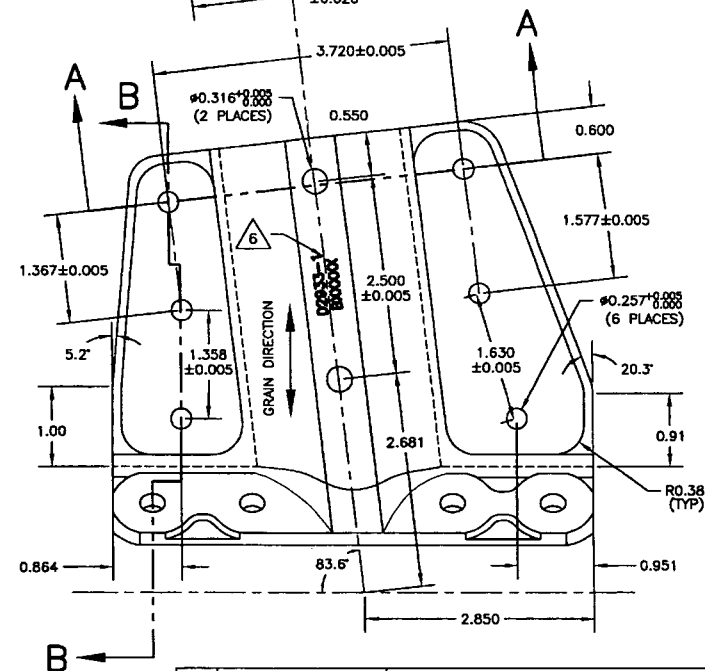
Measured by: J.F.
Date: 07/07/24

Audited by: J.F.
Date: 07/07/25


Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D8101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE

DESIGN <i>AH</i>	DRAWN BY <i>CB</i>	 DART AEROSPACE USA, INC. BELLEVILLE, ILL.
CHECKED <i>AH</i>	APPROVED <i>AH</i>	
DATE 06.11.09		DRAWING NO. D2933 TITLE SADDLE INSIDE

REV. 0
 SHEET 1 OF 2
 SCALE

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DART DART AEROSPACE USA, INC.

DRAWING NO.	REV. C
D2933	SHEET 1 OF

TITLE	SCALE
SADDLE INSIDE	2:1

PAID

07.03.12

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RETURN TO
ENGINEERING
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WITHOUT NOTICE
WORK ORDER
NO. 33354